

5/14

DART AEROSPACE LTD.		Work Order :	22763
Description: Console Bracket (Hi-Slope)		Part Number:	D2606
04.10.18 18 04.10.18 18			
Drawing: D2606 Rev. A I		Qty:	19 20



Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	JP	05.03.17	20
2	CNC-CELL / METAL	Cut Blanks 2.43 X 9.03 (Grain along 9.03, offset 10°) Material: 2024-T3 (.040 Thick) Batch: M16578	EN	05.04.16	20
3	HAAS	Machine per folio D2606	EN	05.04.16	20
4	QC	Inspect Level 2	EN	05.04.16	20
5	QC	Inspect Level 8	ml	05.04.16	20
6	METAL	Deburr and Form per Dwg D2606.	SB	05.04.13	19 PTO
7	QC	Inspect Level 5	JP	05.04.15	19
8	FINISHING	Acid etch & alodine as per QSI 005	ml	05-04-15	19
9	STORES	Identify and Stock	ml	05-04-15	19
10	EXPEDITING	Close W/O Inspect level 21 Job Cost / Job 6.96 SAC 05/04/19 19	JP	05.04.20	19

Rev	Date	Change	Revised By	Approved
A	96.07.27	New Issue		
B	98.05.08	Added drawing revision	KB	
C	98.11.16	Updated Cut Size	KS	
D	98.11.26	Added Inspection	DM	
E	02.06.05	Added alodine finish TSR1290	NG	PP 2/6/16

RELEASED

02/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22763		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/04/13	6	1 scrap bend over tolerance	 05-04-13	Destroy	SB 05/04/13	2 05-04-13	 05-04-13	2 05-04-13

Part No: D2606 PAR #: _____ Fault Category: Product NCR: Yes No DQA: 1 Date: 05/04/20

NOTE: Date & initial all entries

~~Quality Assurance/Quality Control~~
Product/FAIR ABS - Small, Med

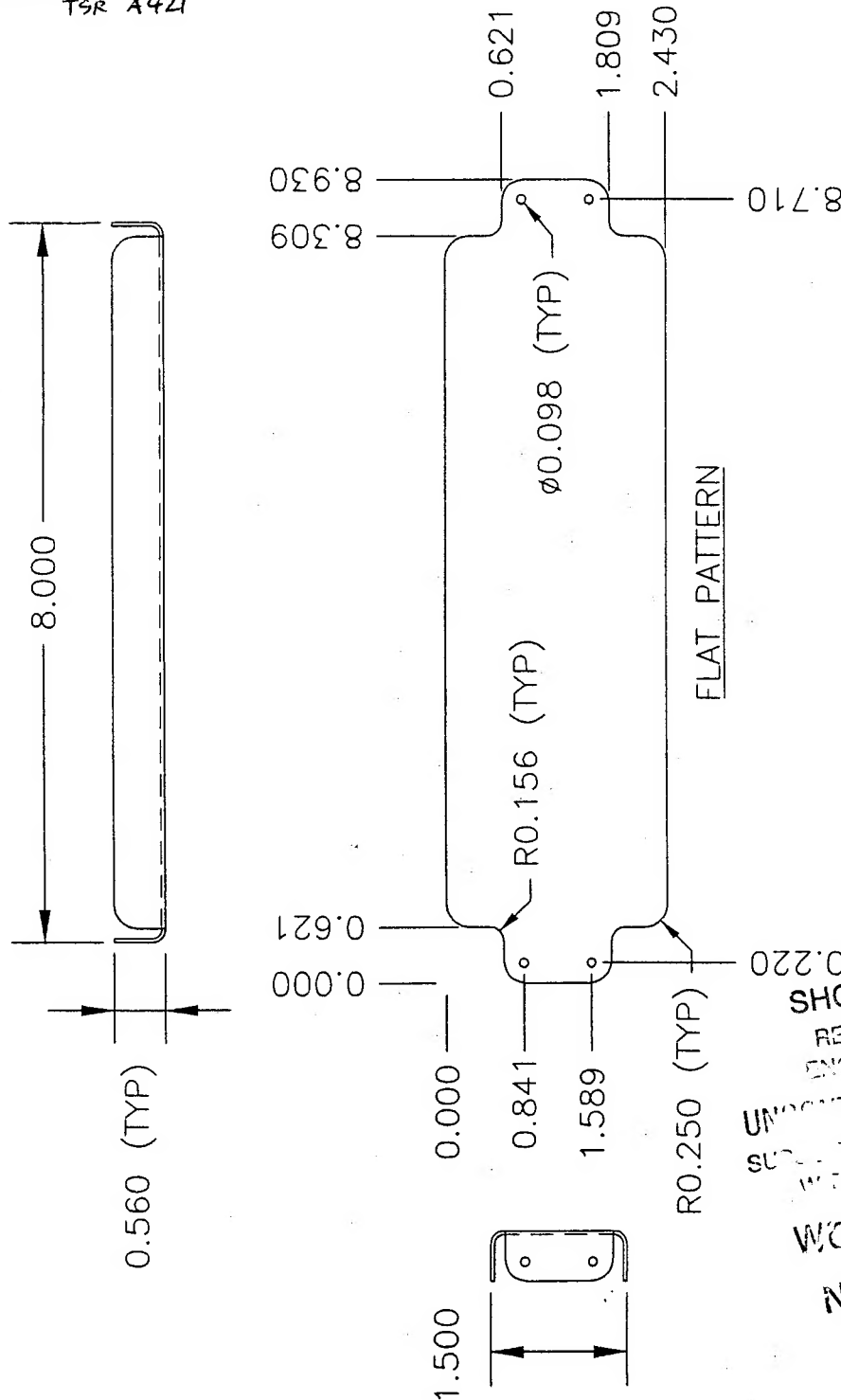
QA: N/C Closed: 4

Date: 05.04.20



DESIGN <i>LE</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>LE</i>	APPROVED <i>CF</i>	DRAWING NO. D2606	REV. A SHEET 1 OF 1
DATE 97.10.23		TITLE CONSOLE BRACKET	SCALE 1:2
A	97.10.23	D2606 WAS D206-547-27	
AI	CP	02.06.04	ADD FINISH

RELEASED
97.11.04 KE
TSR A421



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO
WITHOUT NOTICE
WORK ORDER
NO. 22763

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2606
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART Q51 05 41 /AI

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 17, 2005
02:16 pm

Work Order No : 0022763
Project Name : D2606
Project For : WK514
Work Order Type : Main
Main WO Number :
House Part Number : D2606
Description : Hi Console Bracket
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 03-17-05
Est Finish Date : 04-07-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00